110

QC2- Inspect parts off machine FAI/FAIB

2- Deburr if necessary

0.00

\*110\* QC

Memo

0.00

B13-1-3

Insp.

Quality Control

Page 1

											DQA:	Date	e:
NCR:	Yes	/ No				WORK ORDER NON-O	CON	IFORI	MANCE / UPI	DATE			
						_					QA Closed:	Date	e:
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No						Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite				Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	lı	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												·	
			1	1	•	F	AUL	T CATE	GORY				
Landi	ng (	Gear				General							
		Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled		Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N	ct issing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	Inspection Strip in Tube				<u> </u>	Cut Too Short	$\vdash$	Misrea		<u> </u>	Power Loss/		Other
		Ripples in		TUDE		Drill Holes	-	Offset	~	_	J. 54461 2000)		15.000
ļ		1		Extrusio	, <u> </u>	Drawing	$\vdash$		Calibration				
		Torque Waves in Extrusion Turning Sequence				Finish	$\vdash$		Sequence				

Outside Dimensions

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

pl 13-01-4

		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

NCK:	Yes	/ No	4		*	WORK ORDER NON-C	CON	FURI	VIAINCE / UP	DATE	QA Closed:	Date	<u>:</u> :	
Work Ord	er:					DISPOSITION			:	AGAINST D	EPARTMENT	/PROCESS		
	Part No.					Rework Scrap		Skid-tube Crosstube  Machining Small Fab			Pro	Water Jet Engineering Prod. Eng. Coor. Quality		
NCR No.						Use-as-is Work Order Update		Thermoforming Finishing Rec/Store/Packate  Large Fab Composite Superior Sup			re/Packaging Supplier	Other		
Root					Descri	ption of work order update	In	itial	Ac	tion	Sign &		·	
Cause		Date	Step	Qty	(	or Non-conformance	Chie	ef Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data	Ш			ĺ										
Equip/Tooling	Ш												.   ,	
Operator	Ш											′		
Material	Ш							_				:		
Setup	Ш								[					
Other	Щ													
Process	Н	i												
Supplier Training	Н													
Unapproved														
onapproved		<u> </u>	1	1	1		ΔΙΙΙΤ	CATE	GORY			1		
Landi	ng (	Gear				General					<u></u>			
		Bending				Bend		Grain			Ovalized	Γ	Pressure/Forced	
	$\vdash$	Centre No	ot Conce	ntric to	o/s	BOM/Route	-	Hardwa	are		Over/Under	tolerance	Temperature/Cure	
		Cracks				Broken/Damaged	П	nspect	ion Incomplete		Part Incorre	ct	Weld	
	П	Crushed/Crimped.				Burrs		nstruct	tions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled	
		Cuffs				Contamination		Mainte	enance		Part Moved	_	_	
					Countersink		Mislabe	eled		Positioned \	Wrong _			
	Inspection Strip in Tube Cut Too Short			Cut Too Short	ا	Misrea	đ		Power Loss,	/Surge	Other			
		Ripples in	Bend			Drill Holes	Offset							
		Torque W	/aves in l	Extrusio	n 🗌	Drawing		Out of	Calibration					
		Turning Sequence				Finish	1 (	Out of:	Sequence					

Outside Dimensions

Wave/Twist in Tube

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Monday, December 24, 2012 11:05:41 AM

Work Order ID:

94901

Parent Item:

D3935-1

Parent Item Name:

Pylon Wall Protector, LH

Start Date: 12/24/2012

Required Date: 1/3/2013

Start Qty: 3.00

Required Qty: 3.00

Comments:

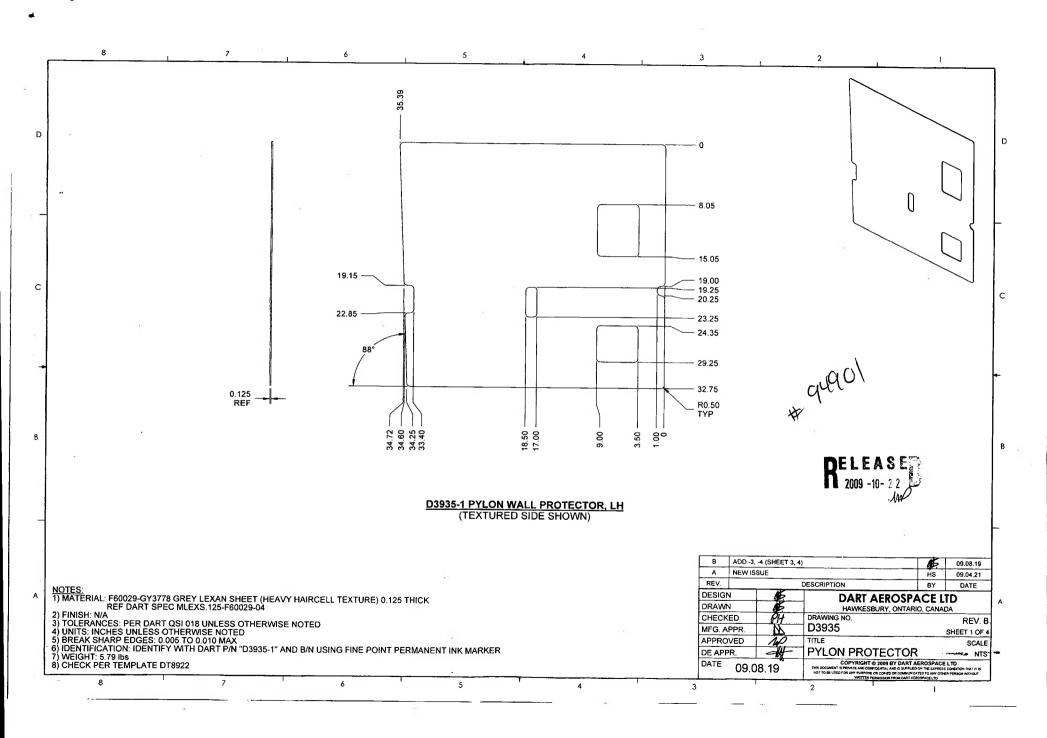
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04 GE PLASTICS LEXAN SI	неет	Purchased	No	· · · · · · · · · · · · · · · · · · ·		100	sf	555.0613	8.69	27.442105	B	3-1-	3
				Location		Loc Qty	Lo	c Code					
				MAT019		555.0613					12		
				121	803	555.0613			121	RUZ	(3)		

												DQA:	Date:	
NCR:	Yes	/ No					WORK ORDER NON-C	O	NFORM	ANCE / UP	DATE			
										· · · · · · · · · · · · · · · · · · ·		QA Closed:	Date:	
Nork Ord	er:						DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
	rt No					Rework Scrap Use-as-is		Therm	Skid-tube Machining Moforming	Crosstube Small Fab Finishing	┥	Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other	
NCR	NCR No. Work O						Work Order Update			Large Fab	Composite	J	Supplier	┙
Root	Description of work order updat								nitial	Ac	tion	Sign &		
Cause		Date Step Qty or Non-conformance					r Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator faterial etup ther rocess upplier raining														
	1	<u> </u>					F	AUL	T CATE	GORY		L		
Land	ing (	Gear					General						<u> </u>	
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Grain  Hardware  Inspection Incomplete  Instructions Incomplete/Unclear  Maintenance  Mislabeled  Misread  Over/Under tolerance  Part Incorrect  Part Lost/Missing  Part Moved  Positioned Wrong  Power Loss/Surge  Offset  Out of Calibration			et ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other			
		Turning Sequence Finis					Finish		Out of 9	Sequence			4	

Outside Dimensions

Wave/Twist in Tube

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DQA:	Date:	

NCR: Yes / No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

									QA Closed:	Date	2:
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No	o				Rework Scrap Use-as-is Work Order Update	-	Skid-tube  Machining  moforming  Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved											
		•			F	AULT CATE	GORY				
Landin	g Gear				General				_		
- - - - - - - -	Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion  BOM/F Burrs Contam Counte Cut Too				Contamination Countersink Cut Too Short Drill Holes Drawing	Instructure Maint Mislab Misrea Offset Out of	tion Incomplete tions Incomplete, enance eled d Calibration	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
-	Turning Sequence Finish Wave/Twist in Tube Folio				Folio	<b></b>	Sequence e Dimensions		<del></del>		

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DART AEROSPACE LTD	Work Order: 9490	7
Description: Pylon Wall Protector, LH	Part Number: D393	5-1
Inspection Dwg: D3935 Rev: B	Page 1	of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing	T-1	Actual			Method of	
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
8.05	+/-0.030	8.05	2		T Bdi	
15.05	+/-0.030	10.05	2		7	
19.00	+/-0.030	19.00	~		7	
19.25	+/-0.030	19.05	t.		7	
20.25	+/-0.030	2025	8		7	<del></del>
23.25	+/-0.030	23.26	2		7	- 1/11
24.35	+/-0.030	24.35	7		-	
29.25	+/-0.030	29.26	2		4	
32.75	+/-0.030	76.68	2			<del></del>
1.00	+/-0.030	1.00	2		7	
3.50	+/-0.030	3,50	2		1	
9.00	+/-0.030	9.00	2			· · · · · · _ · _ · _ · _ · _ · · _ · · · · · · · · · · · · · · · · · · · ·
17.00	+/-0.030	1700	L		7	
18.50	+/-0.030	1 '	8		9	
- 33.40	+/-0.030	33.40	7		7	
34.25	+/-0.030	30.05			<u>-</u>	
34.60	+/-0.030	34,60	1			
34.72	+/-0.030	34.78	2			
22.85	+/-0.030	28.86	L		7	
19.15	+/-0.030	19.15	i		1	······································
35.39	+/-0.030	35.34	2		V Buz	
0125	+/-0.010				A IBUC	
v			OA		^	

Measured by: 🖟		Audited by:	2,89	Preliminary Approval:	N/A
Date: \}	2-1-3	Date:	13.13	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	09.06.22	New Issue	KJ iΛ	
В	10.08.18	Dwg Rev updated	KJ X	1

			÷								DQA:	Date:	
NCR:	Yes /	No				WORK ORDER NON-C	CON	FORM	AANCE / UPD	ATE			
											QA Closed:	Date:	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part No.  NCR No.						Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite				Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other	
Root					Descri	ption of work order update	In	nitial	Actio	on	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Chi	ef Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	Ш										ļ		
Operator	Ш		i										
Material				ŀ									
Setup									8				
Other	Ш												
Process										, ,			
Supplier										The second second			
Training													
Unapproved													
							AULT	CATE	GORY				
Landi	ng Gea				_	General	_				1		7
	-	ending				Bend	-	Grain			Ovalized		Pressure/Forced
						BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks Broken/Damaged					Broken/Damaged	$\vdash$	-	on Incomplete		Part Incorre	<u> </u>	Weld
	Crushed/Crimped. Burrs				Burrs		Instruct	ions Incomplete/U	nclear	Part Lost/M	ssing	Wrong Stock Pulled	
	Cuffs Contamination				Contamination		Maintenance Part Moved						
	Heat Treat Counte				Countersink		Mislabe	eled		Positioned V	Vrong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

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